

NCR 19-7671



Dart Aerospace Ltd.
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D5706-1**Job Sheet 195582****Part No:** D5706-1**Job Qty:** 5 pcs**Part Name:** Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/27/19**Job Tracking No:****Due Date:** 6/21/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG 5706 REV:A8 IPP REV A 19.01.25 NEW ISSUE RQ VERIFIED BY DP**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 5 Axis	5		6/21/19	0.00	6.67	HAAS - 5		Am 9/07/08
		pcs							
110	QC 2	5		6/21/19	0.00	0.00	QC 2 - 1		Am 9/07/08
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S196394**Part:** D5706-1**Job No:** 195582**Serial No/Batch:** S196394**Revision:** B**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 07/08/19

Plex 5/27/19 9:52 AM Dart.lajeunesse.marie

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					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 QC 7	5 pcs	6/21/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	31 19-7-8
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
150 Powdercoat - 1 White GI(A)- B4B	5 pcs	6/21/19	0.00 0.33		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	5 pcs	6/21/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
170 Packaging 3-1 - Stock - B4B	5 pcs	6/21/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PZ ST 181
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	5	6/21/19	0.00 0.00	QC 21 - SA - 21	DAS 21 JUL 10 2019
	pcs			QC 21 - SA - 70	8-85
Part Op 100 - ****WARNING GRAIN DIRECTION**** 1-Cut blanks at 2.00" 2-Machine as per folio FC585 FOLIO REV: Descriptions: AA DWG REV: B 3-Debur 150 - START TIME: OVEN TEMPERATURE: FINISH TIME:					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B2.000X04.500	6061T6 Bar 2.00 X 4.500	.8300 ft (.166 ea)	100-HAAS 5 Axis	5158133	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 5 Axis	M6061T6B2.000X04.500	1	14	0	
Part Specifications					
Specifications could not be found.					

MAT
wco.
8541

Plex 5/27/19 9:52 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	195582
Description: BRACKET		Part Number:	05706-1
Inspection Dwg: D5706	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
25°	±1/2°	25°	—		C-square	
.746	±.010	.746	—		Vern HI-08	
R.38	±.030	R.380	—		R-6	
Ø.375	±.0010	Ø.375	—		Vern HI-08	
1.48	±.030	1.480	—		"	
10X45°	±.030X±1/2°	10.3X45°	—		"	
2.37	±.030	2.380	—		"	
78°	±1/2°	78°	—		C-square	
.420	±.010	.420	—		Vern HI-08	
.375	±.010	.375	—		"	
.188	±.010	.188	—		"	
.580	±.010	.548	—		"	
13X45°	±.030X±1/2°	11.7X45°	—		"	
1.125	±.010	1.125	—		"	
R.19	±.030	R.190	—		R-6	
2.08	±.030	2.080	—		Vern HI-08	
Ø.480	±.0008	Ø.483	—		"	
.740	±.010	.740	—		"	
R.25	±.030	R.250	—		R-6	
.60	±.030	.600	—		Vern HI-08	
2.26	±.030	2.260	—		V "	
Ø.625	±.010	Ø.628	—		"	
Ø1.000	±.000	1.995	—		"	
.035	±.010	.034	—		"	
.090	±.010	.091	—		"	
.255	±.010	.255	—		"	
.165	±.010	.165	—		"	
R.25	±.030	R.250	—		R-6	

Measured by: <i>gml</i>	Checked by: <i>WSP</i>	QC Inspector:
Date: 19/07/08	Date: 19/07/08	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: JK Date: Oct 3/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7671

Route update only ☐

Job: <u>195582</u> Part No. <u>05706-1</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>2019-07-08</u>	Sequence #:	QTY Affected: <u>5</u>		MRB (QSI042) <u>INSP</u> <u>12</u> <u>4/19/18</u> Completed By <u>4/19/18</u> Lead hand / Supervisor <u>19/07/18</u> QC / QA Coordinator <u>DAS</u> <u>55</u> <u>9-89</u> <u>31 JUL 2019</u>	
Description Work Order Deviation Part was made from plate instead of bar. Fm/Fry = 42/36 (plate), Fm/Fry = 42/35 (bar) as strong or stronger.		Disposition <u>Acceptable.</u>			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☒ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			